

Date: Monday, 17/07/2006 11:15:47 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 27931	
Estimate Number : 10310	
P.O. Number : N/A	Part Number : D26175
This Issue : 17/07/2006 S.O. No. : N/A	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 27544	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 24/07/2006
Checked & Approved By : <u>[Signature]</u>	Qty: <u>14</u> Um: Each
Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.0205 f(s)/Unit Total : 0.2048 f(s)
6061-T6 Round Bar 1.5"
Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)
Ø0.500" tubing x 0.058" wall
M6061T6T0.500W.058)
Batch M100309

[Signature] 06/07/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617
2-Deburr

N/A Machined Manually

[Signature] 06/07/19 14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/07/19 14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.07.19 14

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Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAI 06/07/21

(10)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SB 06/07/21 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST33

* does not scan

AL 06/07/21

(10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/08/21

(10)

Job Completion



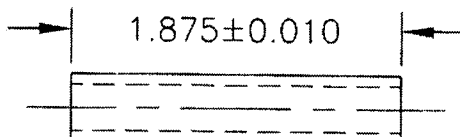
CL 06/07/21



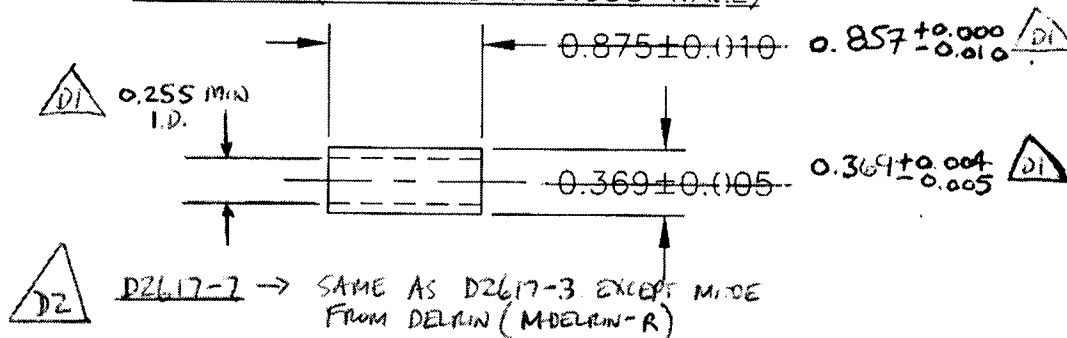
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	
		HAY KESBURY, ONTARIO, CANADA			
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE		TITLE		SCALE	
01.07.04		BUSHING		1:1	

DZ	04.09.10	#	CP	ADD D2617-7	A	96.10.08	NEW ISSUE
					B	97.05.08	.875 WAS 1.125
					C	97.06.04	0.369 DIA WAS 0.375
					D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
					D1	CP	04.07.12 CORRECT TOLERANCE (NCR 774)

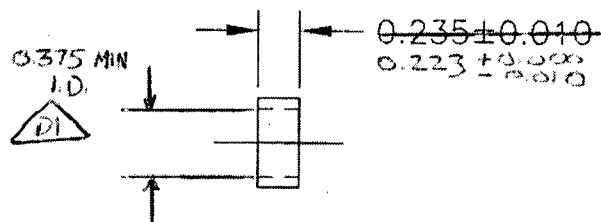
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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